

Work Order ID 64814

Thursday, December 16, 2010 2:14:52 PM

Page 1

Item ID: D3640-1

Revision ID:

Item Name: Belt Guide

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 12/21/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 10/12/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3640

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.700 " long

SL 10/12/20

6

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA670 & Dwg D3640 Rev: A 1-2-Deburr and Blend
rad intersection with deburring tool.

SL 10/12/23 6

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/12/22

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 64814

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Item ID:	D3640-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Belt Guide				Stop	
Start Date:	12/16/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	12/21/2010	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>and 10/12/23</i>			<i>6</i>	<i>0</i>		
140  Packaging Packaging	Identify as per dwg & Stock Location: <i>243</i> Memo	0.00 0.00				<i>10/12/23 (6)</i>			
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<i>10/12/23 (4)</i>			

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Picklist Print

Thursday, December 16, 2010 2:14:56 PM

Page 1

Work Order ID: 64814

Parent Item: D3640-1

Parent Item Name: Belt Guide



Start Date: 12/16/2010

Required Date: 12/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB0.75X1.250		Purchased	No			100	f	27.9024	0.4	2.526316			



Delrin Bar



10/12/20

Location

MAT050

14535

Loc Qty

27.9024

27.9024

Loc Code

2.6

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69814
Description: Belt Guide		Part Number:	D3640-1
Inspection Dwg: D3640 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.50	+/-0.030	4.501	✓		Verin SL-3	
0.80	+/-0.030	.803	✓			
0.13	+/-0.030	.129	✓			
0.31	+/-0.030	.311	✓			
0.200	+/-0.010	.200	✓			
0.40	+/-0.030	.393	✓			
0.03 x 45°	+/-0.030 x 0.5°	.03 x 45°	✓			
0.23	+/-0.030	.229	✓			
0.40	+/-0.030	.401	✓			
0.625	+/-0.010	.632	✓			
R0.13	+/-0.030	.125	✓			

Measured by:	SL	Audited by:	mf	Prototype Approval:	N/A
Date:	10/12/23	Date:	10/12/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

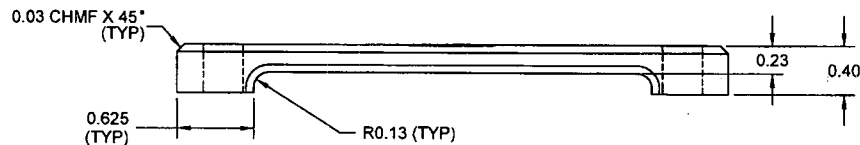
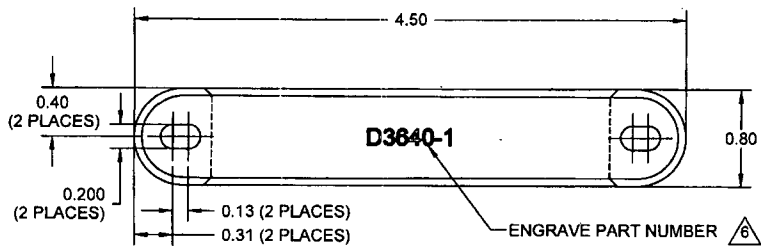
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

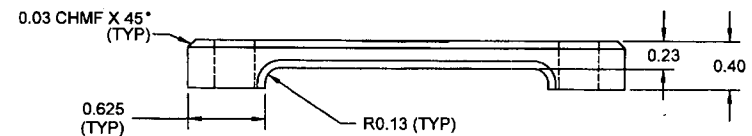
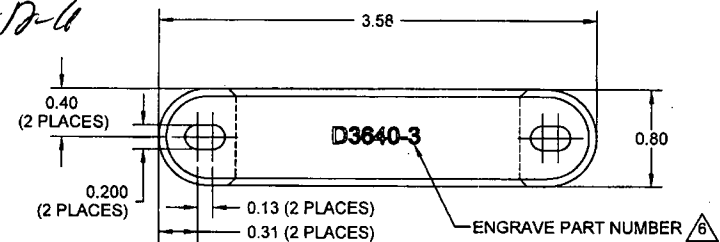
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 648146
B/O D-4



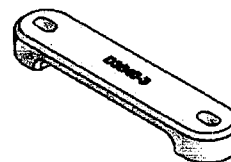
D3640-1 BELT GUIDE
 (WAS GENEVA P/N G10605-1)



D3640-3 BELT GUIDE
 (WAS GENEVA P/N G10605-2)

RELEASED
 07-09-01

- NOTES:**
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
 - 7) WEIGHT: 0.03 lbs



A	NEW ISSUE; REPLACES G10605	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS		
DRAWN	LE		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.27		

DART AEROSPACE USA, INC.	REV. A
PORT HADLOCK, WA	SHEET 1 OF 1
DRAWING NO. D3640	SCALE 1:1
TITLE BELT GUIDE	

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